

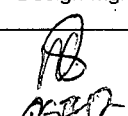



DART AEROSPACE LTD		Work Order:	23349
Description: Hi - Step Leg Assembly		Part Number:	D3065-041
Dwg: D3065 Rev. A1 A2 RF 03.02.17 RF 03.02.28		Qty:	60 56
		Page 1 of 2	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg. not required RF 02.11.04 (Minimum lots of 30)	DF	05.05.20	60
2	MV	Cut blanks: 3.600" x 4.500" (grain along 4.500") male 75 Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick of D3065-1 (M2024T3S.040) Batch M17948 Identify as D3065-1 4.320" RF 02.11.25 4.320"	BSG	05.08.06	75
3	MV	Cut blanks: 6.600" x 4.250" (grain along 4.320") 4.250" RF Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick 02.11.13 (M2024T3S.040) Batch M17948 02.11.25 Identify as D3065-3	BSG	05.08.07	61
4	MV	Cut blanks: 4.580" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch M17948 Identify as D3065-7	BSG	05.08.06	60
5	MV	Cut blanks: 16.61" x 8.51" (grain along 8.51") for each leg. Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch M17790 Identify as D3065-5 M17695 (Note: make 2 legs per assembly)	BSG	05.06.20	120
6	MV	Cut blanks: 16.490" x 0.750" for each spacer. (-0.00/+0.010) Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch M17695 Identify as D3066-1 (Note: make 2 spacers per assembly)	SA	03.06.20	120
7	MV	Machine D3065-1 as per folio FA182 and Dwg D3065, use stack of 15.	BSG	05.08.09	75
8	MV	Deburr to take measurement	BSG	05.08.09	75
9	QC2	Inspect parts as they come off the CNC machine	BSG	05.08.09	75
10	QC8	Second check	BSG	05.08.09	75
11	MV	Machine D3065-3 as per folio FA180 and Dwg D3065, use stack of 15.	BSG	05.08.07	60
12	MV	Deburr to take measurement	BSG	05.08.07	60
13	QC2	Inspect parts as they come off the CNC machine	BSG	05.08.07	60
14	QC8	Second check	BSG	05.08.07	60
15	MV	Machine D3065-7 as per folio FA181 and Dwg D3065, use stack of 15.	BSG	05.08.08	60
16	MV	Deburr to take measurement	BSG	05.08.08	60
17	QC2	Inspect parts as they come off the CNC machine	BSG	05.08.08	60
18	QC8	Second check	BSG	05.08.08	60
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	BSG	05.08.08	60

Step 31 PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-09-08	31	12X D3065-041 Assemblies are scrap, Deep damage and distor- tion from riveting.		Scrap: destroy center step spacers are bent to step logs, too much time to drill out rivets. new employee (SPD)	SB 05/29/08	 05-09-08	 05-09-08	 05-09-08

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/09/13

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____


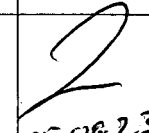

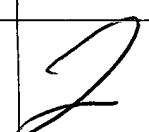
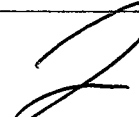
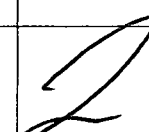
DART AEROSPACE LTD		Work Order:	23349
Description: Hi - Step Leg Assembly		Part Number:	D3065-041
RF 03.02.28			
Dwg: D3065 Rev. A2		Qty:	60
RF 03.02.17			Page 2 of 2

Step	Location	Procedure	By	Date	Qty
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	SA	05.06.20	120
20	MV	Deburr to take measurement	SA	03.06.20	120
21	QC2	Inspect parts as they come off the CNC machine	SA	05.06.20	120
22	QC8	Second check			
23	MV	Machine D3066-1 as per Folio FA280 and Dwg D3066, use stack of 10.	SD	05.06.20	120
24	MV	Deburr to take measurement	SD	05.06.20	120
25	QC2	Inspect parts as they come off the CNC machine	SD	05.06.20	120
26	QC8	Second check			
27	GA	Deburr D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1 stack.	SA	05/06/21	120
28	GB	Bend D3065-1, D3065-3 & D3065-7 as per Dwg D3065	FF	05.08.11	120
29	QC5	Inspect work to Step 28	FF	05.08.14	120 (PTO)
30	FP	Chemical conversion coat as per QSI 005 4.11 RF 02.11.06 D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1.	SB	05/08/14	120
31	GA	Assemble as per Dwg D3065 and identify as D3065-041 Assembly. Qty Part Number Description Batch 1 D3065-1 Spacer B23349 B22959 1 D3065-3 Spacer B23349 B22959 2 D3065-5 Leg B23349 B22959 1 D3065-7 Spacer B23349 B22959 30 MS20470AD4-4 Rivet M16163 M17243 M16199	SB	05/09/08	56 PTO
32	QC5	Inspect work to Step 31.			
33	GA	Identify and Stock D3065-041 Hi-Step Leg Assembly D3066-1 Spacer	PD	05-09-12	56
34	AC	Cost / part 44.67	540	05-09-13	56
35	DC	Close W/O 40.72 Inspect Level 21		05/09/13	56

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	SM	
B	02.09.10	Re-format; Incorporated D3065-1/-3/-5/-7	KJ	
C	02.11.01	Incorporated D3066-1 IPP	KJ RF	

RELEASED
02/11/04 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/08/23	28	D 3065-3 pieces are .010 under tolerance		Acceptable, will modify Sig. DT 8174 to avoid the under tolerance.		 05-08-23		 05-08-23
05/08/23	28	1 piece was scrap D 3065-1		Scrap + destroy	SB 05/08/23	 05-08-23		 05-08-23
05/08/23	27	1 piece was scrap D 3065-5		Scrap + destroy	SB 05/08/23	 05-08-23		 05-08-23

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 17, 2005
10:51 am

Work Order No : 0023349
Project Name : D3065-041
Project For : WK532
Work Order Type : Main
Main WO Number :
House Part Number : D3065-041
Description : Step Leg Assembly
Manufactured : Yes
Amount Req'd : 60
Amount Done : 0
Start Date : 05-17-05
Est Finish Date : 06-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

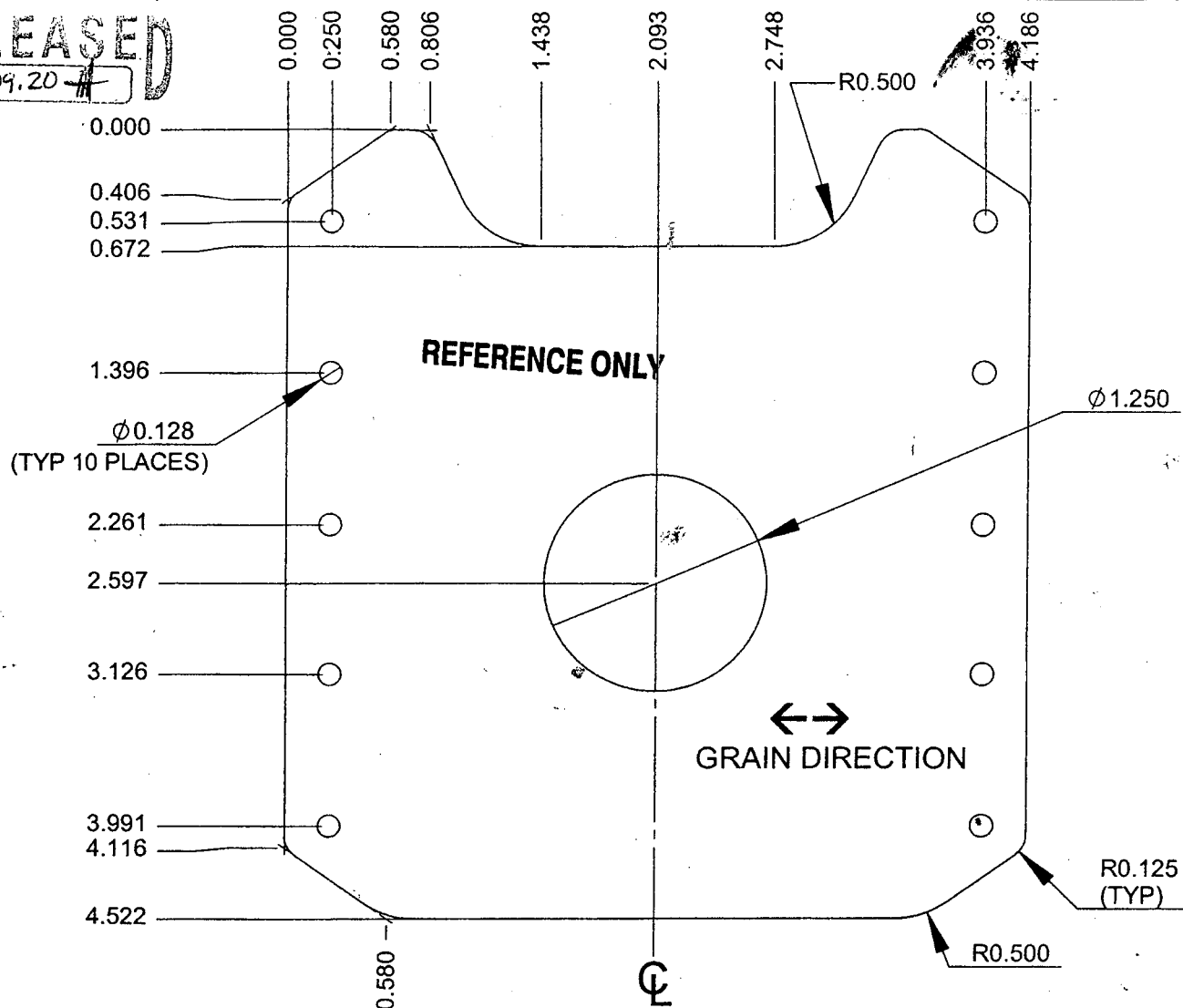
	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

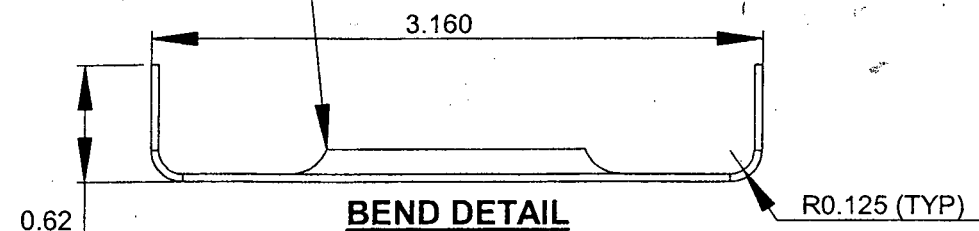
CONTROLLED COPY**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3065	REV. A SHEET 5 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED
02.09.20 #

**FLAT PATTERN**

FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

COPYRIGHT ©2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.